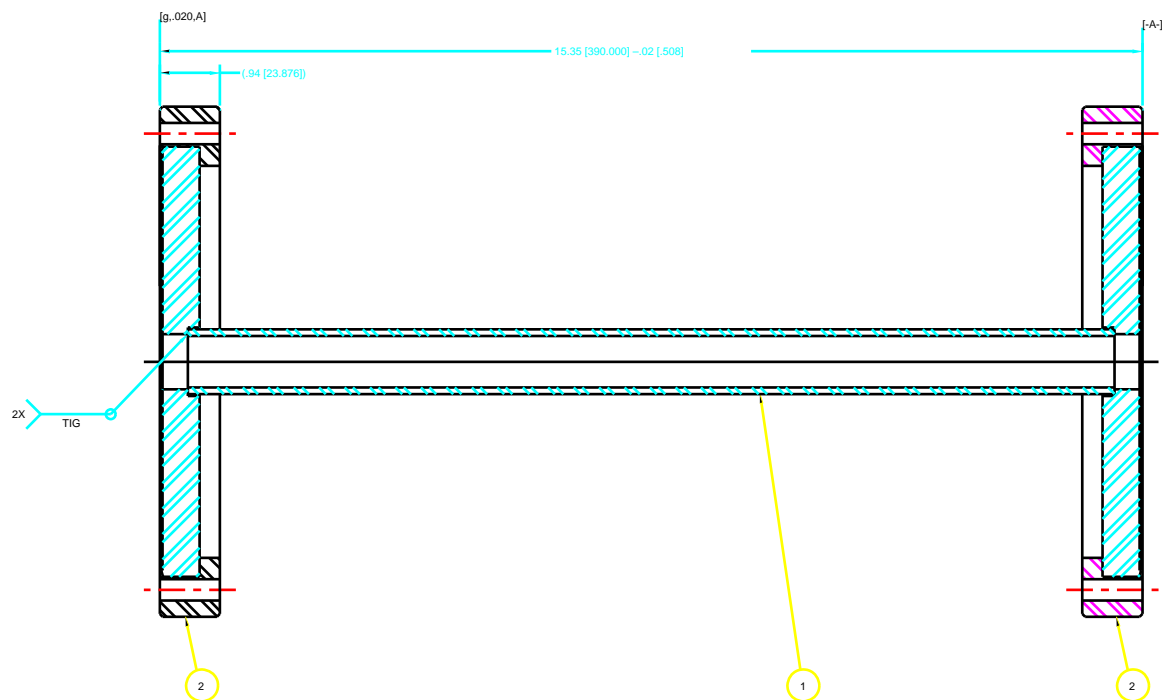
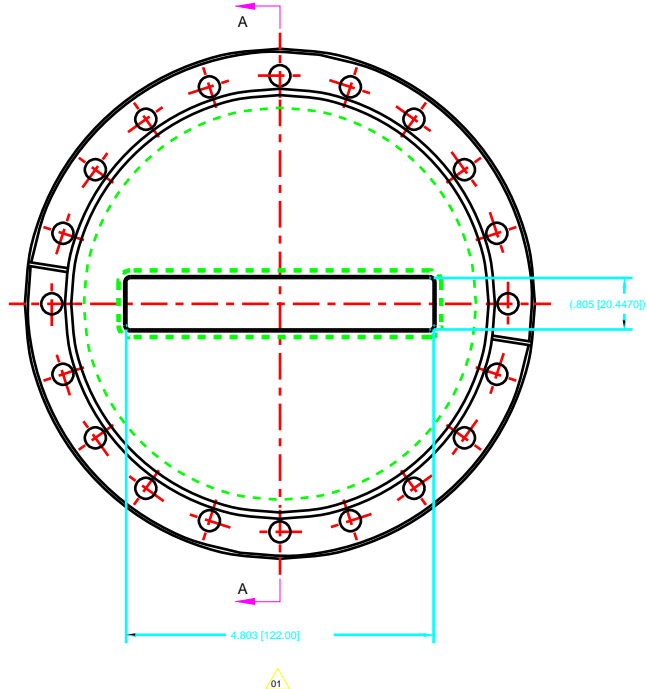


(D)	PLOT SCALE: 1=1	DWG. SCALE: 1	A09895
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SECTION A-A

NOTES:


1. MODIFY FROM PURCHASED PART:
ROTATABLE FLANGE; MDC #100030
2. CHAMBER ASSEMBLY SHALL BE LEAK TESTED USING A MASS
SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF
2 x 10⁻¹⁰ STANDARD CC/SEC PER LEAK METER DIVISION,
SUCH AS:
- ALCATEL SAM-110TCL
DuPONT CEC 24-120B
VARIAN MS-9, MS-90 OR MS-18

CALIBRATION OF THE LEAK DETECTOR SENSITIVITY SHALL BE PERFORMED JUST PRIOR TO TESTING.

FINAL TESTING WILL CONSIST OF SURROUNDING THE CHAMBER (BAGGING) WITH HELIUM, THE CHAMBER WILL BE REJECTED IF A 2% DEFLECTION ON THE MOST SENSITIVE RANGE OF THE LEAK DETECTOR IS SENSED WITHIN 1 MIN.

3. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
4. DIMENSIONS IN [] ARE MILLIMETERS AND FOR REFERENCE ONLY.

01	4.803 WAS 5.197 & UPDATED BOM	DB		
SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				

2	P4102010102-220102-01	K2 END FLANGE		SST	2															
1	P4102010102-220101-01	K2 RECTANGULAR TUBING		SST	1															
ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION		MATERIAL / SPEC	QTY															
<div><div><p>UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES TOLERANCES</p><table><tr><td>DECIMALS</td><td>ANGLES</td></tr><tr><td>.X - .015</td><td>.001</td></tr><tr><td>.XX - .005</td><td>.0005</td></tr></table><p>SURFACE ROUGHNESS 125</p><p>REWORK ALL SURFS AND BREAK SHARP EDGES TO MAX. SURFACE TEXTURE TO BE IN ACCORDANCE WITH SAE-AS9100 AND MIL-1 DIMENSIONING TO TOLERANCING IN ACCORDANCE WITH ASME Y14.5</p><p>DO NOT SCALE DRAWING</p></div><div><p>LOG NUMBER A0989501</p><div></div><p>THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY</p><div><div><p>DESIGNED BY RICK KRAKORA</p><p>CHECKED BY T. SANCHEZ</p><p>DATE 4/27/93</p><p>DESIGNER RICK KRAKORA</p><p>RESPONSIBLE ENGINEER T. SANCHEZ</p><p>DATE 4/27/93</p></div><div><p>CHIEF DESIGN/ENGINEER D. SHU</p><p>GP LEADER M.L. KUZAY</p><p>PROJECT MGR APPROVED/RELEASED</p></div></div></div><div><p>DATE 4/28/93</p><p>FILE ADVANCED PHOTON SOURCE</p><p>K2 B.M. SECOND COLIMATOR VACUUM CHAMBER WELDMENT ASSEMBLY</p><table><tr><td>SCALE</td><td>SIZE</td><td>DRAWING NUMBER</td></tr><tr><td>Sheet 1 of 1</td><td>D</td><td>P4102010102-220100-01</td></tr><tr><td>Surf 1 of 1</td><td></td><td></td></tr></table></div></div>						DECIMALS	ANGLES	.X - .015	.001	.XX - .005	.0005	SCALE	SIZE	DRAWING NUMBER	Sheet 1 of 1	D	P4102010102-220100-01	Surf 1 of 1		
DECIMALS	ANGLES																			
.X - .015	.001																			
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SCALE	SIZE	DRAWING NUMBER																		
Sheet 1 of 1	D	P4102010102-220100-01																		
Surf 1 of 1																				

TITLE ADVANCED PHOTON SOURCE

K2 B.M. SECOND COLLIMATOR
VACUUM CHAMBER
WELDMENT ASSEMBLY

SEE B.O.M.

SCALE	1=1	SHEET 1 of 1
SHEET	1 of 1	

DRAWING NUMBER
P4102020102-220100-01